

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020747**Date Inspected:** 18-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for random observations relative to the work being performed.

Bay 14

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Wang Xu, CWI as Bao Qian.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; 14E

PCMK: SEG3007L

Weld No: 062,066

Welder: 066163

WPS-B-P-2213-B-U2-FCA-1

Components; 14E

PCMK: SEG3019AA

Weld No: 025

Welder: 215553

WPS-345-SMAW-2G(2F)-FCM-Repair

WELDING INSPECTION REPORT

(Continued Page 2 of 5)

Repair No. CWR2755

Components; 14E

PCMK: SEG3019BB

Weld No: 115

Welder: 067610

WPS-B-P-2114-FCM-1

Components; 14E

PCMK: SEG3019Z

Weld No: 007

Welder: 037932

WPS-B-P-2214-TC-C5b-FCM

Components; 14AE

PCMK: SEG3007AB

Weld No: 016

Welder: 037743

WPS-345-SMAW-3G(3F)-FMC-Repair-1

Weld Repair No. WR20116

Components; 14AE

PCMK: SEG3007AB

Weld No: 087

Welder: 037743

WPS-345-SMAW-3G(3F)-FMC-Repair-1

Weld Repair No. WR20116

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Wang Xu, CWI as Bao Qian.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; 13AE

PCMK: SEG3007B

Weld No: 131

Welder: 055564

WPS-B-P-2232-ESAB

Components; 13AE

PCMK: SA3357

Weld No: 019

Welder: 070046

WELDING INSPECTION REPORT

(Continued Page 3 of 5)

WPS-B-P-2132-ESAB

Components; 13E

PCMK: SEG3019L

Weld No: 137, 142, 149,

Welder: 066733

WPS-B-P-2233-ESAB

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Li Ping, CWI as CK Chen.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; 14W

PCMK: DP3174-001

Weld No: 018

Welder: 037780

WPS-B-P-2212-TC-U4b-FCM

Components; 14W

PCMK: DP3174-001

Weld No: 019

Welder: 066480

WPS-B-P-2212-TC-U4b-FCM

Components; 14W

PCMK: SEG3020L

Weld No: 030

Welder: 037780

WPS-B-P-2114-FCM-1

Components; 14W (see photo below)

PCMK: SEG3020BB

Weld No: 055

Welder: 045246

WPS-345-SMAW-2G(2F)-FCM-Repair-1

Weld Repair No: CWR2752

Components; 14W

PCMK: SEG3020BB

Weld No: 046

Welder: 066038

WPS-345-SMAW-2G(2F)-FCM-Repair-1

WELDING INSPECTION REPORT

(Continued Page 4 of 5)

Weld Repair No: CWR2752

This Caltrans QA Inspector observed at random intervals ZPMC performing grinding of welds located in Lift 14W on SA3445 at various locations due to contour grinding and visual indications as identified by ZPMC QC Inspectors. (see photo below)

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Li Ping, CWI as CK Chen.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; 13W (see photo below)

PCMK: SEG3020BB

Weld No: 109

Welder: 067764

WPS-B-T-2233-ESAB

Components; 13W

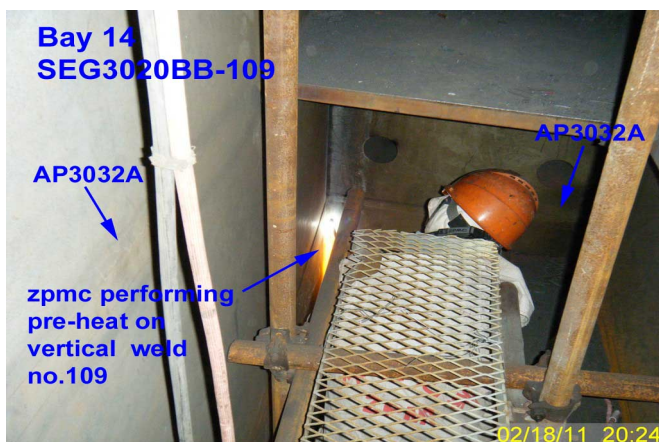
PCMK: SEG3013P

Weld No: 011

Welder: 067876, 066421

WPS-B-T-2132-ESAB

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



WELDING INSPECTION REPORT

(Continued Page 5 of 5)



Summary of Conversations:

No significant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 1500026784, who represents the Office of Structural Materials for your project.

Inspected By:	Leavitt,Kelly	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
